

~~Insert~~ TITLE: SUPERCONDUCTING TAPES

FIELD OF THE INVENTION

The present invention relates to a superconducting tape and more particularly to a composite superconducting tape.

5 BACKGROUND OF THE INVENTION

The invention has been developed primarily for carrying alternating current and will be described hereinafter with reference to that application. It will be appreciated, however, that the invention is not limited to that particular field of use and is also suitable for carrying direct or non periodically varying current.

10 Tapes comprising superconducting material, and referred to as superconducting tapes, are already known, and comprise one or many superconducting filaments in a medium of silver or silver alloy. Superconducting tapes are used to make coils, magnets, transformers, motors and generators as well as current carrying cables. The main class of superconducting tape is referred to as powder-in-tube or PiT tape. This tape is made  
15 by drawing or otherwise reducing a tube of silver, or less usually silver alloy, which is filled with a powder form of a superconducting oxide. The tube is then subjected to further rolling to form it into a thin tape. Multifilamentary tapes are mostly made by grouping a plurality of filled tubes in a common silver or silver alloy sheath at an intermediate stage of reduction.

20 One important superconducting oxide is known as Bi-2223. This oxide includes bismuth, strontium, calcium, and copper and, as would be known to those in the art, certain limited substitutions can be made. This oxide can be considered a cuprate salt.

Known tapes usually have a thickness of between around 0.2 mm and 0.3 mm, and a width of between 2 mm and 5 mm. The superconducting filaments must be thin to  
25 obtain an adequate critical current. A typical thickness is around 10 to 40 microns. Moreover, a typical aspect ratio is at least 1:10.

The filaments comprise many plate-like grains and, for good performance, the grains should be, as much as possible, aligned in the same crystallographic orientation. The relative orientation is often referred to as the grain alignment or "texture". Thin,  
30 well textured filaments allow a high critical current and give overall flexibility to the whole tape.

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10 DISCLOSURE OF THE INVENTION

According to the invention there is provided a composite superconducting tape  
15 comprising a multiplicity of constituent superconducting tapes stacked parallel to one  
another with major faces in contact, and is characterised in that at least some of the  
constituent tapes have widths not greater than half the width of the composite  
27 superconductor and are laid edge to edge with each other.

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Preferably also, the full-width metal tape is at one end of the stack. More  
30 preferably, two full-width metal tapes are provided, one at each end of the stack. Even  
more preferably, if there is only one metal tape or two tapes are unequal strength, that

the metal tape is used in a construction in which the tape, or the stronger tape respectively, is always on the convex side of any curve, as more fully explained in U.K. patent application no. 9805644.3.

In some embodiments one full-width superconducting tape is used.

5 Preferably, the superconducting tape is diffusion-bonded and all its elongate components extend longitudinally, as described in UK patent application no. 9805641.9.

In a preferred form, a metal tape is used which is flat and has a width not substantially greater than that of the superconducting tapes. In some embodiments the width of the metal tape is slightly less than that of the superconducting tapes. In still  
10 further embodiments, however, a wider metal tape is used which is, or subsequently becomes, bent to a channel section. Although the latter arrangement would have structural advantages it would adversely affect fill factor. Similarly, the use of a silver foil or other compatible material wrapped around the stack but extending longitudinally is not excluded.

15 Preferably, diffusion bonding of the superconducting tapes and, if present, the metal tapes, is achieved by assembling the tapes face to face and heat-treating at a temperature low enough to avoid any deleterious effect on the superconducting material. When the superconducting material has a typical BSCCO-2223 composition, the temperature should not exceed 842°C. Provided control is close enough, a temperature  
20 of 840°C is recommended.

A diffusion time at temperature of several hours will be required to achieve adequate bonding. It will be appreciated, however, that excessively long periods are undesirable as tending to produce too much sintering of the superconductor material.

Preferably the diffusion-bonded stack of tapes is rolled to reduce overall thickness  
25 and to strengthen the bonding.

Unless the context clearly requires otherwise, throughout the description and the claims, the words 'comprise', 'comprising', and the like are to be construed in an inclusive sense as opposed to an exclusive or exhaustive sense; that is to say, in the sense of "including, but not limited to".

30 BRIEF DESCRIPTION OF THE DRAWINGS

Preferred embodiments of the invention will now be described, by way of example only, with reference to the accompanying diagrammatic drawings (not to scale) in which:

Figure 1 is a cross-section of a composite superconducting tape according to the invention; and

5 Figure 2 is a cross-section of another embodiment of a composite superconducting tape according to the invention.

#### PREFERRED EMBODIMENTS OF THE INVENTION

The composite superconducting tape shown in Figure 1 has a width of between 4 and 5.5 mm and a thickness of about 0.27 mm and comprises (for example) eight stacked  
10 monofilamentary tapes 12 bonded together. Each monofilamentary tape 12 comprises a filament 5 of superconducting material, for example, BSCCO-2223 in a silver/silver alloy cladding 7 as with known superconducting tapes. Typical, in the finished product as shown, each individual monofilamentary tape 12 has a thickness of 50  $\mu\text{m}$  and the filaments 5 themselves have typical thicknesses of 10 to 40  $\mu\text{m}$ . The constituent tapes  
15 12 each have a width substantially equal to half the width of the composite tape and they are arranged with a full-width silver bridging tape 13 in two sub-stacks 15 with a zone 16 between them that is substantially free of superconductor filaments.

The tape of Figure 2 is similar except that there are silver and/or silver alloy tapes 13 and 14 at both the top and bottom ends of the stack.

20 To make either of the superconducting multifilamentary tapes shown in the drawings, the required number of monofilamentary tapes 12 must be made. The monofilamentary tapes 12 are made by firstly packing BSCCO-2223 oxide powder (or more usually a precursor convertible to the Bi-2223 composition by heat-treatment) into a cleaned and dry tube of silver or silver alloy having an internal diameter of  
25 approximately 8 mm and an external diameter of approximately 10 mm. A length of between 4 cm and 6 cm - depending upon the length of the silver tube - at one end of the tube is then swaged, and the tip of the swaged end closed off using smaller swaging dies, to prevent powder loss during packing. After swaging, the tube is again dried. The prepared tube is then carefully filled with the superconducting powder (precursor) under  
30 dry argon in a glove box. The powder is added small amounts at a time and tamped down with a silver rod until the tube is full, at which point the tube is closed off using a

plug of silver tape. After the tube has been packed with superconducting powder and sealed, then the tube is degassed by placing it in a cool oven, in air, raising the temperature to 830°C and maintaining that temperature for five hours. The tube is then drawn in a number of stages down to a diameter of approximately 1.11 mm. The drawing is done in 27 steps in each of which the cross-sectional area of the tube is reduced by approximately 15%. During drawing, the tube is twice annealed at 500°C for between 30 and 60 seconds, when its diameter is 2.51 mm and 1.96 mm.

The 1.11 mm wire is then rolled in a rolling mill with a roll diameter of 200 mm, in stages to successive smaller thicknesses using roll gaps of 0.80, 0.65, 0.50, 0.40, 0.35, 0.30, 0.25 and 0.22 mm, twice annealing for between 30 and 60 seconds at 500°C, at thicknesses of 0.65 mm and 0.35 mm.

The tape is then cut into eight strips of equal length and stacked in two stacks as shown with one or two metal tapes (about 0.22 mm thick) as required and the stack of tapes wound on a former of ceramic material (with ceramic paper strip interleaved to prevent bonding of turns). It may be desirable to square the edges of the taps (by trimming or otherwise) before stacking to minimise risk of creating voids between the columns. The tapes are then heated at 840°C for about five hours to effect diffusion bonding and then, after being cooled to room temperature, rolled in stages to 0.32 mm using successive roll gaps of 1.00 (when there are two metal tapes), 0.80, 0.65, 0.55, 0.45, 0.38, 0.35, and 0.32 mm, annealing under the same conditions as before at 0.80 mm and 0.55 mm.

The composite tape is then heated in air, starting with a cool oven, to 840°C and held at that temperature for 50 hours, cooled to room temperature and rolled once on the same mill with a roll gap of 0.28 mm. Finally it is heat-treated in an atmosphere of 7.5% oxygen balance nitrogen, starting with a cold oven, heated to 825°C, held at that temperature for 40 hours and then cooled over a further period of 40 hours to 785°C. This heat-treatment regime serves to consolidate it, complete texturing and convert the precursor to the desired BSCCO-2223 phase without risking melting of any large volume fraction of the superconducting material.

The embodiment described above has used eight monofilamentary constituent tapes 2 and a final thickness between 0.25 and 0.3 mm. However, more or fewer tapes

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